

Work Order ID 149186 -1 split

149186

Page 1

Thursday, July 21, 2016 10:54:26 AM

Item ID: D4635-4 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Aft Ceiling Panel, RH
 Start Date: 7/21/2016 Start Qty: 2.00 *2* 1.2m
 Required Date: 7/28/2016 Req'd Qty: 2.00 *2* 1.2m Cust Item ID:
 Reference: Customer:

Approvals: Process Plan: 2m Date: 10/01/21 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4635	F								
100	HAND FINISHING THERMOFORMING	0.00							DAS 07 9-89
100						2			14/08/17
Thermoform	Memo	0.03							
Thermoforming Machine	Cut Blanks								
105	Dry Material	0.00							DAS 07 9-89
105						2			14/08/17
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Dry Sheet as per QSI022 POLYCARBONATE								
Temp:	245 deg. F								
Time IN:	5:00 PM								
Time OUT:	6:00 AM								

AUG 16 2016

Per.....

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Work Order ID 149186

Thursday, July 21, 2016 10:54:26 AM

149186

Page 2

Item ID: D4635-4**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop*****NS2*****Item Name:** Aft Ceiling Panel, RH**Start Date:** 7/21/2016 **Start Qty:** 2.00***2*****Cust Item ID:****Required Date:** 7/28/2016 **Req'd Qty:** 2.00***2*****Customer:****Reference:****Approvals:****Process Plan:** _____**Date:** _____**Tooling:** _____**Date:** _____**Run Start*****NR1*****QC:** _____**Date:** _____**SPC (Y/N):** _____**Date:** _____**Stop*****NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

110

0.00

110

Thermoform

Thermoforming Machine

THERMOFORMING MACHINE

Memo

0.11

Thermoform as per Dwg. D4635-4 and Folio FTA150

Dwg. Rev. 8Folio Rev. 15NOTE: Check moulds prior to using to ensure proper placement of add-ons.
Visually inspect for proper formation and texture2DAS
07
9-89

16/08/17

130

0.00

130

Thermoform

Thermoforming Machine

HAND FINISHING THERMOFORMING

Memo

0.68

Trim to Finished Dimensions

2DAS
07
9-89

16/09/08

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		3-82 01	
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval 072	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 149186

Thursday, July 21, 2016 10:54:26 AM

149186

Page 3

Item ID: D4635-4 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Ceiling Panel, RH
Start Date: 7/21/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 7/28/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC6- Inspect dimensions to drawing Dimensional Inspection Memo Fill out Inspection Sheet Rev A	0.00 0.00				2			DAS 07 9-89 16/09/08
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01				(XC)			DAS 16 9-89 16/09/15
160 *160* Packaging Packaging	Packaging Memo	0.00 0.00							W/O 149101 Dh. 16/09/29

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☒

Work Order: <u>149186</u> Part No. <u>04635-4</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS					
				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
				Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
				Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
				Large Fab ☐	Composite ☐	Supplier ☐			
Date : _____		Step #: <u># 140</u>		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition			<u>8/16/13</u>		
<u>Power chan to ac2</u>				<u>_____</u>			Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval <u>QY2</u>		
Root Cause		FAULT CATEGORY							
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐		
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐		
				Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐		
				Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐		
				OTHER : _____					

Work Order ID 149186

Thursday, July 21, 2016 10:54:26 AM

149186

Page 4

Item ID: D4635-4

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Ceiling Panel, RH

Start Date: 7/21/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/28/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
Qty **DAS**Reject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00

170**21**
9-89

SEP 29 2016

QC

Memo

0.03

Quality Control

Jem 10/09/29

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Thursday, July 21, 2016 10:54:26 AM

Work Order ID: 149186

149186

Parent Item: D4635-4

D4635-4

Parent Item Name: Aft Ceiling Panel, RH

Start Date: 7/21/2016

Required Date: 7/28/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev. A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev.
B Dwg. Update 12/11/08 DL IPP Rev C Dwg.
Update 13/07/09 DL IPP Rev. D Dwg, Update,
Material Change 13/12/18 DL IPP Rev. E Dwg. Update 14/01/09
DL IPP Rev F Dwg, Update 15/01/27 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	380.9000	9.39	18.78			DAS 07 9-89

MI FXS 093-F6006-07

GE PLASTICS LEXAN SHEET (Grey)

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT023	380.9	
m129738	380.9	

M 13532220h

18.78 sq ft.

16/08/17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval a-28 03 DWS		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

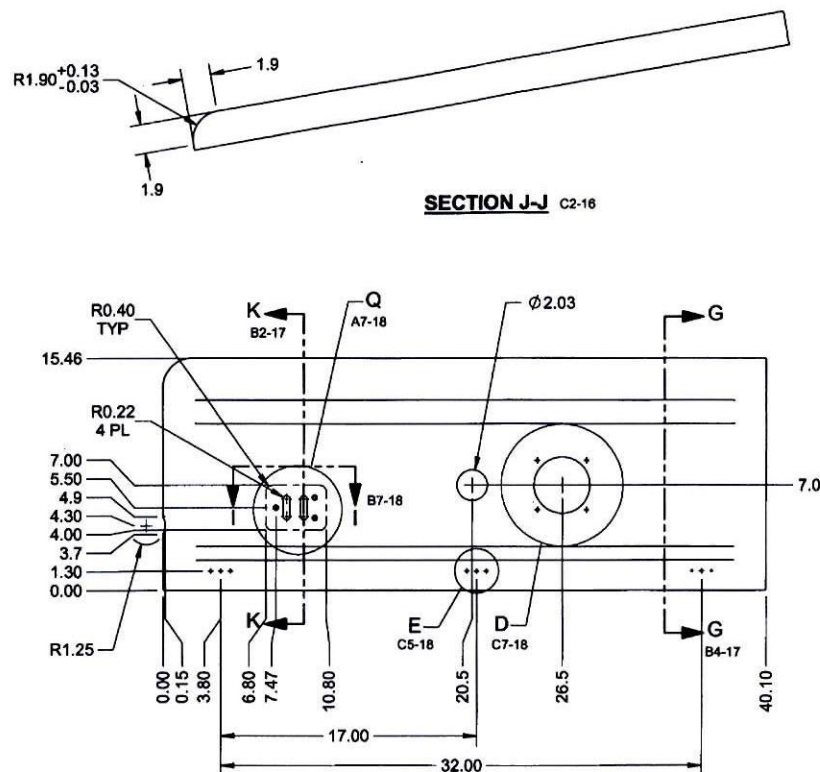
DART AEROSPACE LTD		Work Order:	149186
Description: RH Aft Ceiling Panel		Part Number:	D4635-4
Inspection Dwg: D4635	Rev: E F 01	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.80	+/-0.030	3.83"	✓			
17.00	+/-0.030	17.00"	✓			
32.00	+/-0.030	32.00"	✓			
7.47	+/-0.030	7.5"	✓			
20.5	+/-0.100	20.6"	✓			
26.5	+/-0.100	26.6"	✓			
7.0	+/-0.100	7.1"	✓			
5.50	+/-0.030	5.58"	✓			
Ø2.03	+0.012/-0.001	Ø2.03"	✓			
3.300	+/-0.010	3.3"	✓			
1.650	+/-0.010	1.65"	✓			
3.300	+/-0.010	3.3"	✓			
1.650	+/-0.010	1.65"	✓			
Ø0.191	+0.005/-0.001	Ø0.191"	✓			
Ø3.50	+0.012/-0.001	Ø3.53"	✓			
1.300	+/-0.010	1.30"	✓			
0.650	+/-0.010	0.65"	✓			
Ø0.129	+0.005/-0.001	Ø0.129"	✓			
1.380	+/-0.010	1.38"	✓			
0.43	+/-0.030	0.42"	✓			
1.61	+/-0.030	1.606"	✓			
0.50	+/-0.030	0.53"	✓			
0.30	+/-0.030	0.33"	✓			
0.35 - 0.40	+/-0.030	0.359"	✓			

Measured by:	DAS 07 9-89	Audited by:	DAS 16 9-89	Preliminary Approval:	
Date:	16/09/08	Date:	16/09/13	Date:	

Rev	Date	Change	Revised by	Approved
A	14.07.29	New Issue	KJ	



D4635-4 RH, AFT CEILING PANEL

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.66 lbs
- 8) TEXTURE ON THIS SIDE
- 9) TRIM D4635-4 PER TOOL DT9842
- 10) THERMOFORM D4635-4 PER QSI 022 USING DT9850 TOOL
MIN. THICKNESS AFTER FORMING:
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

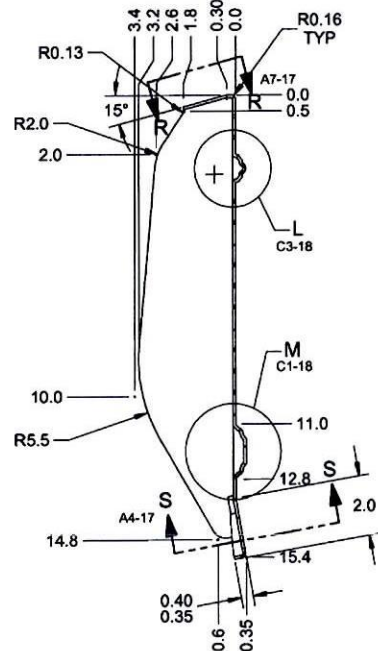
RELEASED

2015 JAN 26

APPROVED

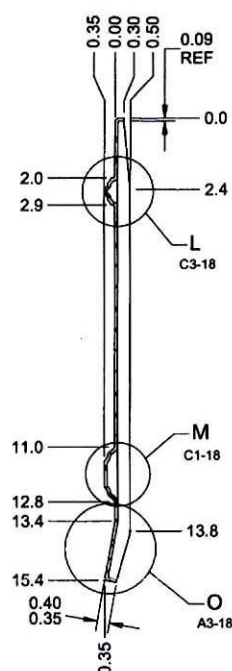
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. F
MFG. APPR.	DL	D4635	SHEET 16 OF 18
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	OUTBOARD CEILING PANELS	NTS
DATE	14.11.28	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

w/o 149186 dm 16/07/21



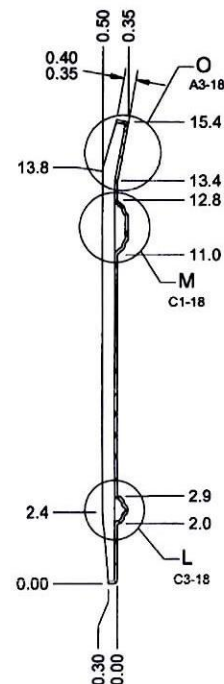
SECTION A-A
SECTION A-A' OPPOSITE
SCALE 2X

B3-13
B3-14



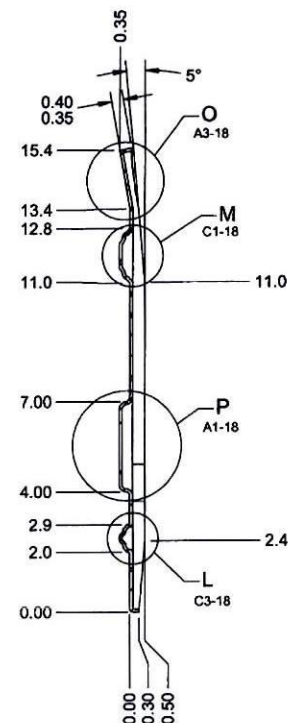
SECTION B-B
SCALE 2X

B7-13
B7-14



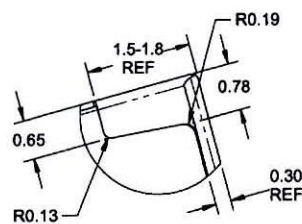
SECTION G-G
SCALE 2X

B4-15
B4-16



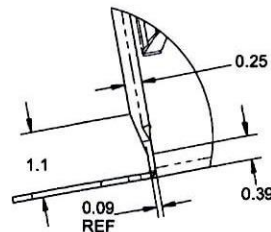
SECTION K-K
SCALE 2X

C6-16



AUXILIARY VIEW R-R
SECTION R-R' OPPOSITE
SCALE 2X

D7-17



AUXILIARY VIEW S-S
SECTION S-S' OPPOSITE
SCALE 2X

B7-17

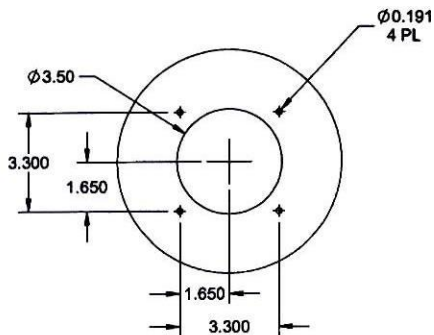
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2015 JAN 26

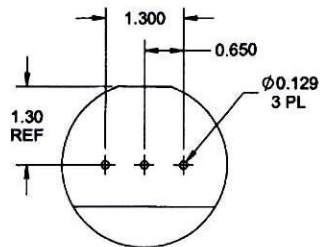
APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. F
MFG. APPR.	DL	D4635	SHEET 17 OF 18
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	OUTBOARD CEILING PANELS	
DATE	14.11.28	NTS	
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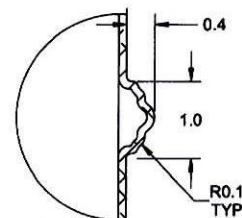
8 7 6 5 4 3 2 1



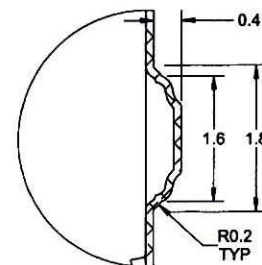
DETAIL D
SCALE 2X
B4-13
B3-14
B5-15
B5-16



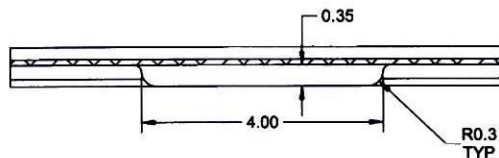
DETAIL E
SCALE 4X
C7-13
B6-14
C8-15
B5-16



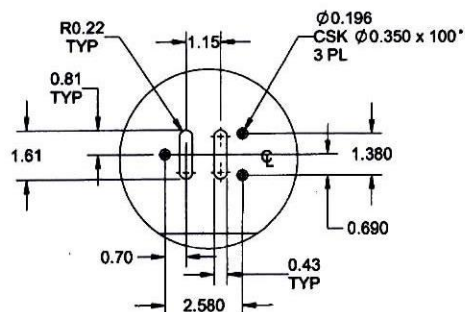
DETAIL L
SCALE 1.5X
B2-17
B4-17
C5-17
C7-17



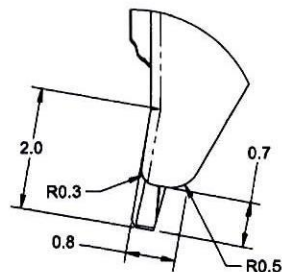
DETAIL M
SCALE 1.5X
C2-17
C3-17
C5-17
C7-17



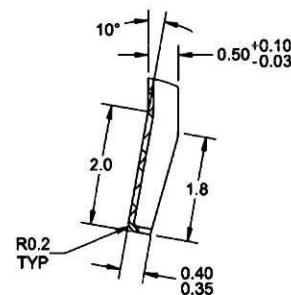
SECTION I-I
SCALE 4X
B5-16



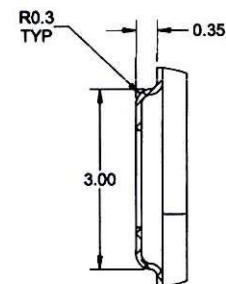
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SCALE 2X
C5-16



DETAIL N
SCALE 2X
B2-13



DETAIL O
SCALE 2X
D2-17
D3-17
B5-17



DETAIL P
SCALE 4X
C2-17

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2015 JAN 26

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DESIGN	RF
DRAWN	RF
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MFG. APPR.	DL
APPROVED	HS
DE APPR.	DS
DATE	14.11.28

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